

Work Order ID 63247 -1

Tuesday, October 26, 2010 10:26:22 AM

split



Item ID: D412-698-015

Accept



Setup Start



Revision ID:

Stop



Item Name: Door Support

Start Date: 10/26/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 8.00

Customer:

Reference:

Approvals: Process Plan:

Date: *10/26/10* Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN D412-698

Rev E

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D412-698-015 CHG001

8/10/11/05

Pl 10-10-26

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

revised

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8/10/11/05

(x1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63247

Tuesday, October 26, 2010 10:26:22 AM



Page 2

Item ID: D412-698-015

Accept



Setup Start



Revision ID:

Stop



Item Name: Door Support

Start Date: 10/26/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-698-015
Location: 22 PPP Rev: A

10/11/15 ①

140

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

10/11/15 J

MF

10-11-5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, October 26, 2010 10:26:27 AM

Page 1

Work Order ID: 63247

Parent Item: D412-698-015

Parent Item Name: Door Support



Start Date: 10/26/2010

Required Date: 10/29/2010

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:C Removed Manufacturing 06-01-25 JLM
IPP Rev:D change to rev D ECN 1104 08-01-28 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN960JD10L

NAS1149D0332J

Purchased

No

Each

0.0000

12

96

Washer

D3200-1

Manufactured

No

Each

17.0000

2

16

Door Post Block

Location

Loc Qty

Loc Code

ST044

17

61691

17

D3200-3

Manufactured

No

Each

11.0000

2

16

Door Wedge

Location

Loc Qty

Loc Code

ST044

11

61517

11

D3201-1

Manufactured

No

Each

13.0000

2

16

Doubler

Location

Loc Qty

Loc Code

ST044

13

62248

13

49x
M114348 M110785 M114967
10/11/10

B63242 (7x) 10/11/20

B62725 (13x) 10/11/20

B63244 10/11/20 (8x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, October 26, 2010 10:26:27 AM

Page 2

Work Order ID: 63247

Parent Item: D412-698-015

Parent Item Name: Door Support

Start Date: 10/26/2010

Required Date: 10/29/2010

Start Qty: 8.00

Required Qty: 8.00

D3201-3
Doubler

Manufactured No

Each

18.0000



1

8

Location

Loc Qty

Loc Code

ST044

18

60064

6

62821

12

Each

15.0000



1

8

D3201-4
Doubler

Manufactured No

Location

Loc Qty

Loc Code

ST044

15

60063

3

62481

12

Each

2,208.000



12

96

MS21042L3
Nut

Purchased No

Location

Loc Qty

Loc Code

ST300

2208

114784

1208

115835

1000

Each

58.0000



12

96

MS24693-S277
Screw

Purchased No

Location

Loc Qty

Loc Code

ST288

1

115457

1

ST289

57

115835

57

Tuesday, October 26, 2010 10:26:27 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

7.0 PARTS LIST - PILOT DOOR MODIFICATION KITS

Qty -015	Qty -023	Part Number	Description
X		D412-698-015	DOOR SUPPORT KIT
	X	D412-698-023	AUTOMATIC DOOR OPENER KIT
2		D3200-1	DOOR POST BLOCK
2		D3200-3	DOOR WEDGE
2		D3201-1	DOUBLER
1		D3201-3	ANGLE
1		D3201-4	ANGLE
	1	D3552-11	GAS SPRING
	1	D3594-5	DOOR DOUBLER
	1	D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	1	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
	2	D3622-1	BALL STUD
	1	MS21073L5	ANCHOR NUT
	2	MS20426AD4-4	RIVET
12		AN960JD10L	WASHER
	2	AN960JD516L	WASHER
12		MS21042L3	NUT (OR MS21042-3)
12		MS24693-S277	SCREW

• COPYRIGHT © 2003 BY DART AEROSPACE LTD •

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: E
Date: 08.05.01